

Work Order ID 151854***151854***

Page 1

Wednesday, October 12, 2016 2:39:51 PM

Item ID: D206-802-032

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Passenger Door Opener RH

Start Date: 10/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: VS Jm Date: 10/10/12

Tooling:

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

DSI9579	B
IIN D206-802-3	A

OCT 13 2016

DAS
6
9-89

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-802-032 CHG004

DAS
27
9-89

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

OCT 13 2016

DAS
6
9-89DAS
28
9-89DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 151854***151854***

Page 2

Wednesday, October 12, 2016 2:39:51 PM

Item ID: D206-802-032

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Passenger Door Opener RH

Start Date: 10/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS
27
9-89

OCT 20 2016

120

Packaging

0.00

120

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPDD206-802-032

Location:

PPP rev:

~~Sold~~ PBP 151852DAS
27
9-89

OCT 20 2016

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

16/10/2016
ME
16-10-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

Wednesday, October 12, 2016 2:39:51 PM

Page 1

Work Order ID: 151854

151854

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 10/12/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC IPP Rev:B
11.10.25 AS PER DSI9579 REV.A DD verf:EC IPP Rev:C 11.12.19
PER DSI9579 REV B DD verf:EC IPP Rev:D 12.07.30 AS PER
ECN12-624 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-17 *D3552-17* Door Prop		Manufactured	No			105	Each	5.0000	1	1			DAS 28 9-89
									**			OCT 13 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST353				4					
				148200				4					
				ST363				1					
				126847				1					
D3622-5 *D3622-5* Ball Stud		Manufactured	No			105	Each	5.0000	2	2			DAS 28 9-89
									**	151850		OCT 17 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST046				5					
				129766				1					
				133920				4					
D4112-1 *D4112-1* Aft Sill Doubler		Manufactured	No			105	Each	0.0000	1	1			DAS 28 9-89
									**	151820		OCT 11 2016	DAS 6 9-89
D4115-5 *D4115-5* Doubler		Manufactured	No			105	Each	11.0000	1	1			DAS 28 9-89
									**			OCT 13 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST084				11					
				148106				11					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

Picklist Print

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Work Order ID: 151854

151854

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 10/12/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

105

Each

1,391.000

4

4

MS20426AD4-5

RIVET

OCT 13 2016

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

1305

m133751

1305

ST312

86

m133751

86

MS20600-AD4W2

Purchased

No

105

Each

330.0000

14

14

MS20600-AD4W2

Rivet

OCT 13 2016

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

203

m126475

6

m135058

47

m135127

150

ST308

127

m134762

127

MS21073L5

Purchased

No

105

Each

37.0000

2

2

MS21073L5

Anchor Nut

OCT 13 2016

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST298

37

m135058

37

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

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Wednesday, October 12, 2016 2:39:51 PM

Page 3

Work Order ID: 151854

151854

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 10/12/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R Purchased No

105 Each 500.0000 6 6

NAS1149C0532R

WASHER

**

OCT 13 2016

DAS 6 28
9-89 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

GA 60
116513 60
ST260a 200
m135390 200
ST266 240
m135671 224
m134756 16

NAS1149C0563R Purchased No

105 Each 396.0000 6 6

NAS1149C0563R

Washer

**

OCT 13 2016

DAS 6 28
9-89 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST265 396
m131697 396

D4108-11 Manufactured No

105 Each 4.0000 1 1

D4108-11

Template

**

OCT 13 2016

DAS 6 28
9-89 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST082 4
85048 4

D4108-047 Manufactured No

105 Each 2.0000 1 1

D4108-047

Sill Doubler Assembly

**

OCT 13 2016

DAS 6 28
9-89 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST083 2
133849 2

Wednesday, October 12, 2016 2:39:51 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Wednesday, October 12, 2016 2:39:51 PM

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Work Order ID: 151854

151854

Parent Item: D206-802-032

D206-802-032

Parent Item Name: Passenger Door Opener RH

Start Date: 10/12/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-4

Purchased

No

105

Each

190.0000

4

4

CR3523-4-4

Rivet

OCT 13 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK003

100

m127255

100

ST318

90

124259

84

m130388

6

D3552-27

Manufactured

No

105

Each

1.0000

1

1

D3552-27

Door Prop

OCT 13 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

Mezz

1

89499

1

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0
REF CANADIAN STC: SH10-44
REF FAA STC: SR02933NY
REF EASA STC: 10033253

1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)

52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
☒		D206-802-031	PASSENGER DOOR OPENER KIT, LH
	☒	D206-802-032	PASSENGER DOOR OPENER KIT, RH

ADD:

	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
	4	CR3523-4-4	RIVET
	1	D3552-27	DOOR PROP

3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
☒	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151854

16/10/12
VCC

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 11.12.07
CERT. NO.: SH10-44
ISSUE NO.: 1

B	ADD DOOR PROP D3552-27	AP	11.12.07
A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
DATE	11.12.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 			
Description Work Order Deviation				Disposition							
								Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY									
Environment	☐	Design	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
	☐		☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
	☐		☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
	☐		☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
	☐		☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
	☐		☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
	☐		☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
	☐		☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
	☐		☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
	☐		☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
	☐		☐	Manufacturing Process	☐	OTHER :							
	☐		☐	Past Due	☐								

4.0 INSTALLATION CHANGE:

4.1 On metal airframe:

No change. Install D206-802-032 using D4112-1 per Section 3.3 of IIN-D206-802-3.

4.2 On composite airframe:

Install D206-802-032 by replacing D4112-1 Aft Sill Doubler with D4108-047 per instructions below and Figure 1 of this Service Instruction.

4.2.1 Perform Step 3.3.1 of IIN-D206-802-3.

4.2.2 Replace Steps 3.3.2 to 3.3.16 with the following:

- a) Using Figure 1 of this Service Instruction, locate D4108-11 Template on the edge of the door post closeout approximately 17.5" from the front of the seat. Match drill the Ø0.128" rivet holes (4 PL) on the door sill. Locate and drill thru template and door sill if the door sill is without existing holes.
- b) Transfer drill the Ø0.128" holes (4 PL) from D4108-11 Template to the D4108-047 Sill Bracket Assembly.
- c) Deburr all drilled holes and clean area.
- d) Remove and retain the Ball Stud and hardware from the D4108-047 Sill Bracket Assembly.
- e) Install D4108-047 Sill Bracket Assembly by applying a thin layer of Proseal 890 and wet installing the CR3523-4-4 Rivets (4 PL) as shown in Figure 1 of this Service Instruction.
- f) Remove excess Proseal, grind rivet stems flush and clean area of any debris.
- g) Re-install the Ball Stud and hardware removed at Step "d)" of this instruction.
- h) Re-position the carpet and interior trim panel. Trim/cut as required for the ball stud and to allow the D4108-047 Sill Bracket Assembly to protrude.
- i) Re-install the scuff plate.
- j) Install rod end of D3552-27 Door Prop onto the Ball Stud mounted on D4108-047 Sill Bracket Assembly.
- k) With the door open and using the D3552-27 Door Prop, Figure 4 and the dimensions shown as reference, position D4115-5 Doubler. Ensure that the door opens far enough for ingress and egress (minimum of 19" wide) and that there is no interference with any structure or interior trims. The final location of the D4115-5 Doubler will vary somewhat from aircraft to aircraft.

4.2.3 Perform Steps 3.3.17 to 3.3.26 of Installation Instructions IIN-D206-802-3.

4.2.4 Replace Step 3.3.27 with the following:

- a) Attach the cylinder end of the D3552-27 Door Prop to the D3622-5 Ball Stud installed on the previous step.

4.2.5 Complete installation of D206-802-032 by following Steps 3.3.28 to 3.3.29 of Installation Instructions IIN-D206-802-3.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 11.12.07
CERT. NO.: SH10-44
ISSUE NO.: 1

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
DATE 11.12.07		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

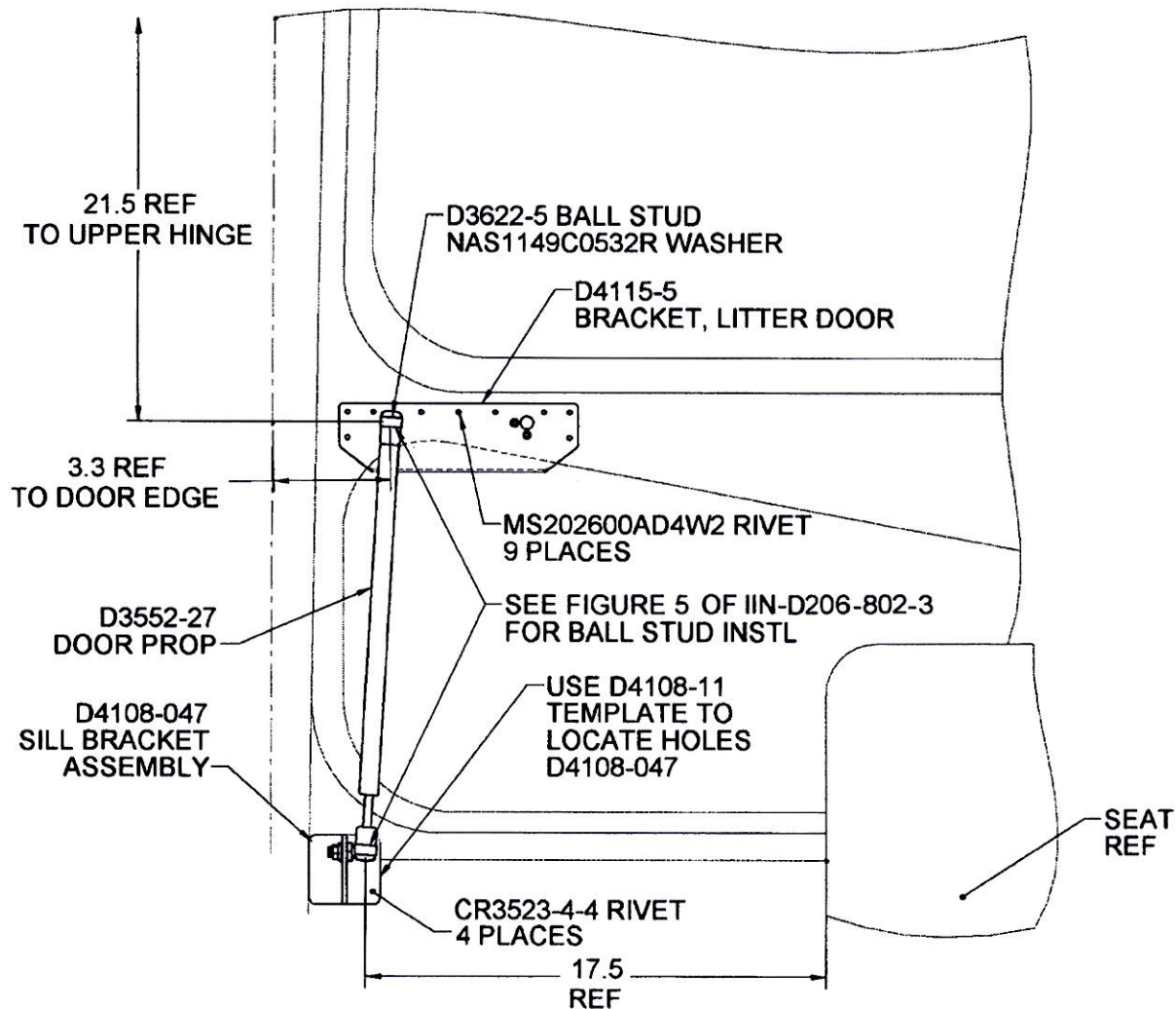


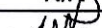
FIGURE 1: INSTALLATION OF D206-802-032 ON COMPOSITE AIRFRAME

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.12.07
CERT. NO.: SH10-44
ISSUE NO.: 1

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

REFERENCE ONLY

DART SERVICE INSTRUCTIONTO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

2.0 PARTS LIST CHANGE:**5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)****52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)**

Qty -031	Qty -032	Part Number	Description
☒		D206-802-031	PASSENGER DOOR OPENER KIT, LH
	☒	D206-802-032	PASSENGER DOOR OPENER KIT, RH

ADD:

	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
	4	CR3523-4-4	RIVET
	1	D3552-27	DOOR PROP

3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
☒	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.12.07

CERT. NO.: SH10-44

ISSUE NO.: 1

B	ADD DOOR PROP D3552-27	AP	11.12.07
A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
DATE	11.12.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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5.0 PARTS LIST

5.1 D206-802-029/-030 Crew Door Opener Kits

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

Work Order ID 151854

Thursday, October 13, 2016 8:31:49 AM

151854

Page 1

Item ID: D206-802-032 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Passenger Door Opener RH
Start Date: 10/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9579	B								
IIN D206-802-3	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-032 CHG004								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

label

DAS
21
9-89

OCT 13 2016